Work Order I			*770	144*						Page 1
Item ID: D34 Revision ID: Item Name: Plug	92-5		Accept	*N900	040	100) * s	Setup Sta	_ 14	S1*
_	1/2011 Start Qty: 40.0			Cust Item Customer:					IV	. T
Approvals: Pro	ocess Plan: M.L.J	Date: \\\\\\ 7	S Tooling:	D	ate:	_	F	Run Sta	1/1	R1*
QC		Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2
D3492	D	•								
100	Hardinge CNC LATI	HE SMALL	0.00	44.4			40	0		Af uluf
Hardinge Hardinge CNC Lathe Smal	Memo II 1-Turn a Dwg Re Folio Re	s per Folio FA634 & Dwg D v:	0.00 3492	**		ą.				
*110	QC2- Inspect parts of	ff machine FAI/FAIB	0.00				40	()		Stulul3
QC Quality Control	Мето		0.00					<u> </u>	· ·	<u> </u>
120	QC8- Inspect parts - :	second check	0.00	٠	lo.		ile	-1		
120 QC Quality Control	Memo		0.00	וון וו פיל	130		46	_ G		

W/O:	1		WC	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<u> </u>		·						
		· *						
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
	Re	esolution:	Disposition	າ:	_ QA: N/C Cld	sed:	Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verification		Approval
	012.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		·						

Work Orde November-25-11				*770	144*							Page 2
Item ID: Revision ID: Item Name:	D3492-5			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	25/11/2011 09/12/2011	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	ID:						
Approvals:		in:	Date:	Tooling: SPC (Y/N):		ate:	- ·		Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 130 *130* Small Fab Small Fab)	Operation Description Small Fab Memo 1-Deburr if n 2-Tumble	eccesary	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
*140 *140* QC Quality Control		QC5- Inspect part comple	teness to step on W/O	0.00		n/a		Julj	111	13	30	
150 *150* HandFinish		Chemical Conversion Coa	at per QS1005 4.1	0.00				40		BL.	11-10	2-1

Hand Finishing

										
W/O:		**************************************	W	ORK ORDER CH	IANGES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NO	R: Yes	No DQ	A :	_ Date: _	
	Re	esolution:	Dispositio	n:	Q/	A: N/C Clo	sed:		Date:	·
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DATE	STEP	Description of NC		Corrective Action	Section B	Cian 9	Verific		Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Descri	ption	Sign & Date	Section	on C	Chief Eng	QC Inspector
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				1.2						
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Work Ord November-25-1				*77(144*		· 				Page 3
Item ID: Revision ID:	D3492-5			Accept	*N900	040	100*	Setup	Start	I VI	
Item Name:	Plug								Stop	*N	S2*
Start Date:	25/11/2011	Start Qty: 40.00	*40*		Cust Item 1	ID:					
Required Date	: 09/12/2011	Req'd Qty: 40.00	*40*		Customer:						
Reference:		·									
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:		Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D a	ate:			Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Acc Code Qty			Reject Number	Insp. Stamp
160 *4 CO*		White Gloss(Ref:4.3.5.1)	per QSI005 4.3-Alum	0.00			11-24	1	, /	/ , /	1 - 1
160 Powdercoat		Memo	(10	0.00			40 X	J_1/1	1-1	-11/1;	2/01
Powder Coating		(Flat End On							/	('	, ,
W/18	439	START TIM OVEN TEM FINISH TIM	PERATURE:	<i>31</i> -							
170		QC3- Inspect Part Finish	*	0.00			,		4		
170							1/1	2 6	SD 11-	12-1	<i>1</i> .
QC		Memo		0.00			—/— (,	7-11		
Quality Control											
180		Identify as per dwg & Sto	ck Location: D.A.	0.00					4.4	_	
1ጸበ							dy	Ø.	BK 1	1-12-	1.
Packaging		Memo		0.00							

Memo

Packaging

W/O:			W	ORK ORDER CHANGE	S		-		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ /	4 :	Date: _	
		esolution:							
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DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
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Work Orden				*77(144*							Page 4
Item ID: Revision ID: Item Name:	D3492-5			Accept	*N900	040	100)*	Setup	Start Stop	1 71	S1* S2*
Start Date: Required Date: Reference:	25/11/2011 09/12/2011	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:						
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
190 *190* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00						\	1/12	1 1

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	URE CHANGE By					Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Y	es N	o DQA	\:	_ Date: _	
	Re	esolution:	Dispositi	on:	QA: N/0	Clos	ed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC Section A	Initial	Action Description		gn &	Verific Section		Approval Chief Eng	Approval QC Inspector
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Picklist Print

November-25-11 8:29:08 AM

Work Order ID: 77044

77044

Parent Item:

D3492-5

D3492-5

Parent Item Name: Plug

Start Date: 25/11/2011

Required Date: 09/12/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.375		Purchased	No			100	f	12.6000	0.06	2.526316			
*M6061T6	SR0 375	*							**	2.663		.45	11/11/30

6061-T6 Round Bar .375"

Location Loc Qty Loc Code MAT012 12.6 2.663 12.6 112567

Dail AC	ospace	Liu												
W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	•	PAR #:	Fault Cate	gory:	NC	R: Yes 1	lo DQ	A :	_ Date: _					
	Re	esolution:	Dispositio	n:	QA	: N/C Clo	sed:		Date:					
NCR:			WORK ORD	ER NON-CONFO	RMANCE	(NCR)								
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval				
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DART AEROSPACE LTD	Work Order:	77044
Description: Plug	Part Number:	D3492-5
Inspection Dwg: D3492 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	\$ 0.3743	V		sloz slug	
Ø0.188	+0.005/-0.001	00.1886	V		и	1
0.045	+0.000/-0.002	0.044			и	
0.500	+/-0.010	0.499			u	
0.060	+/-0.005	0.040	<i>\oldsymbol{\gamma}</i>		`	
0.060	+/-0.005	0.060			ч	·
0.090	+0.000/-0.002	0.0895			n	
·						

Measured by:	A	Audited by: B.A		Preliminary Approval:		
Date: 1////	30	Date:	11/11/30	Date:		

Rev	Date	Change	Revised by Approved
Α	06.07.11	New Issue P/O D3492-045	Revised by Approved
В	06.10.16	Updated to Revision B	KJ/JLM
С	07.10.30	Tolerance revised for Ø0.375	KJ/EC/DD
D	08.11.28	Dwg Rev updated	KJ/EC . A
E	11.06.21	Dwg Rev updated	KJ W

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W/O:			WC	RK ORDER CHANG	ES				
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						•			
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Part No		PAR #·	Fault Cate	nory:	NCR: Yes	No DO	Δ-	Date:	<u></u>
Part No: PAR #:									
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	?)		,	
DATE	STEP	Description of NC		on B		cation	ation Approval	Approval	
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ction C	Chief Eng	QC Inspector
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		,							
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-NAS1611 O-RING (SEE TABLE) D3492-XX PLUG (SEE TABLE)-

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	-047	-049	-051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	11						D3492-3	PLUG
		1					D3492-5	PLUG
			1	-			D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						. 1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	11						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

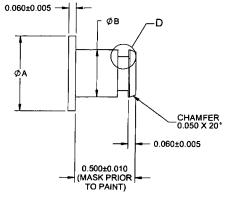
SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER
NO. 77044 M L J
11/11/25 WITHOUT NOTICE

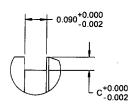
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Α	NEW IS	SUE		PH	06.01.04
В	ADD -04	7; UPDATE DIM .	PH	06.05.11	
С	ADD -04	19/-051/-053, CHA	PH	07.10.05	
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DE APPR.		PLUG	2:1					
DATE 11.0	05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PREVATE AND CONTRIBUTION OF SUPPLIES OF THE EXPRESS CONCENTION THAT IT IS NOT TO BE USED FOR ANY PARPOSE OF DOPED OR COMMERCE TO TO ANY OR THE PRESON WITHOUT						

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		Section A	Initial Chief Eng	Action Description Chief Eng		Date	Section C	n C	Chief Eng	QC Inspector			
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-POWDER COAT THESE FACES ONLY PER NOTE 2





DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

	P/N	A	В	С	MATERIAL SPEC	
	D3492-1	0.625	0.394	0.050	M6061T6R0.625	
	D3492-3	0.750	0.582	0.045	M6061T6R0.750	
7	D3492-5	0.375	0.188	0.045	M6061T6R0.375	
٠	D3492-7	0.500	0.270	0.045	M6061T6R0.500	
	D3492-9	0.938	0.750	0.045	M6061T6R1.000	
	D3492-11	0.850	0.664	0.045	M6061T6R0.875	
	D3492-13	0.750	0.510	0.045	M6061T6R0.750	

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M606116R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

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DRAWN	AS	HAWKESBURY, ON			
CHECKED	K	DRAWING NO.	REV. D		
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DATE 11.0	05.24	THIS DOCUMENT IS PROVATE AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COPPED OR CO	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS COCUMENT IS PROVINE AND CONFIDENTIAL AND IS SUPPLIED ON THE EDWIESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED ON COMMUNICATED TO ANY OTHER PRESIDENT WITHOUT WITHOUTH PRESIDENTIAL PRODUCT LATE OF COMMUNICATION WHITH PRODUCT LATE OF COMMU		

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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign Date	& Sec	cation tion C	Approval Chief Eng	Approval QC Inspector					